

Date: Tuesday, 1/9/2007 4:06:41 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)		
Job Number	: 30213		Part Number	: D2572		
Estimate Number	: 10531		Drawing Number	: D2572 REV E		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 1/9/2007	S.O. No. : JIA	Drawing Revision	: E		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 1/30/2007 Qty: 12 Um: Each		
Previous Run	: 30095					
Written By						
Checked & Approved By						
Comment	: Est: 1 02/10/02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101005	7075-T7351 8.25X5.0X2.5	
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2572 Ensure that grain is along 5.00" length Batch No: <u>B05350</u>			
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
<b>Comment:</b> HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>30213</u> Double check by: <u>JIA</u>			
1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.			
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
<b>Comment:</b> CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2572 PAR #: N/A Fault Category: Prod / Mach. <sup>PHS</sup> NCR:  Yes  No DQA:  QA: N/C Closed: ✓ Date: 07/02/07 Date: 07/02/07

NCR: <u>30213</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/01/22	2.0	Dim Thickness min. 115 is .108 min. .352 is .342. E. Roughly .010 too much was removed from the surface to start casing A .010 offset on the origin.	<u>QH</u> <u>Q51042</u>	I sandblasted the 1st one. part acceptable.	S.F 07/01/23	<u>Q</u> <u>07/01/23</u>	<u>QH</u> <u>Q51042</u>	<u>Q</u> <u>07/01/22</u>
07/01/22	2.0	operation 2.0, origin off., resulting in scrapping part. <u>TOTALLY</u>	<u>Q</u> <u>Q51042</u>	Scrap and replacement. I had made sure it's 1st NC. destroy what's left, if no need to replace.	S.F 07/01/26	<u>Q</u> <u>07/02/01</u>	<u>Q</u> <u>Q51042</u>	<u>Q</u> <u>07/02/01</u>

NOTE: Date & initial all entries

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Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 30213

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Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F/J.F

07/01/27

(12)

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

Co 07/01/28 X12

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M.H/YL

07/02/02

(12X)

7.0 POWDER COATING POWDER COATING



M1103141



(12X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M.H/YL

07/02/05

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

L.7/02/06 (12)



9.0 PACKAGING 1 PACKAGING RESOURCE #1



PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST472

B04/02/06 (12) P. (12)



(12)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

307/02/07

Job Completion



U 07.02.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30213
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	.439	.440"	.440	.440		
B	1.745	1.755		1.750	1.751"	1.751	1.749		
C	3.495	3.505		3.500	3.500"	3.500	3.500		
D	1.745	1.755		1.750	1.751"	1.751	1.750		
E	7.990	8.010		7.990	8.003"	8.003	8.002		
F	0.490	0.510		.501	.500	.506	.500		
G	0.257	0.262	DT8683	.258	.260"	.260	.260		
H	0.375	0.380	DT8684	.376	.376"	.376	.376		
I	0.490	0.510		.500	.494"	.495	.496		
J	1.174	1.184		1.179	1.181"	1.181	1.180		
K	0.558	0.578		.568	.569"	.569	.567		
L	1.174	1.184		1.179	1.181"	1.181	1.180		
M	1.490	1.500		1.495	1.499"	1.499	1.495		
N	2.495	2.505		2.500	2.502"	2.502	2.500		
O	3.869	3.879		3.875	3.877"	3.877	3.874		
P	0.115	0.135		.125	.123"	.120	.121		
Q	0.115	0.135		.125	.135"	.135	.125		
R	0.240	0.260		.252	.251"	.249	.248		
S	0.115	0.135		.125	.130	.129	.128		
T	0.178	0.198		.188	R.188"	R.188	R.188		
U	2.940	2.980		2.965	2.963"	2.963	2.964		
V	0.230	0.250		.240	.230	.233"	.235		
W	0.115	0.135		.125	.120	.126	.131		
X	0.307	0.312		.312	.312"	.312	.310		
Y	0.760	0.765		.764	.764"	.764	.760		
Z	0.352	0.372		.340	.367	.367	.371		
AA	0.470	0.530		.500	R.500"	R.500	R.500		
AB	0.615	0.635		.626	.627"	.627	.627		
AC	0.053	0.073		.063	.063	.063"	.063		
AD	0.240	0.260		.250	.249"	.240	.250		
AE	1.375	1.395		1.394	1.388"	1.387	1.385"		
AF	0.115	0.135		.125	.125"	.125	.125		
AG	0.240	0.280		.250	.250"	.250	.250		
AH	0.240	0.260		.250	.251"	.240	.242		
AI	2.000	2.020		2.001	2.000"	2.001	2.001		
AJ	0.023	0.043		.025	.025	.025	.025		

Accept/Reject

Measured by:	8/JF-J.F.	Audited by:	E.P.
Date:	07/01/22	Date:	07/01/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JLM

DART AEROSPACE LTD				Work Order:	30213
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Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	.438	.438	.439	.438		
B	1.745	1.755		1.750	1.750	1.749	1.749		
C	3.495	3.505		3.500	3.500	3.500	3.501		
D	1.745	1.755		1.750	1.750	1.750	1.751		
E	7.990	8.010		8.002	8.002	7.999	7.999		
F	0.490	0.510		.501	.501	.500	.501		
G	0.257	0.262	DT8683	.250	.258	.257	.259		
H	0.375	0.380	DT8684	.375	.375	.375	.375		
I	0.490	0.510		.497	.497	.497	.504		
J	1.174	1.184		1.180	1.180	1.180	1.180		
K	0.558	0.578		.559	.559	.559	.559		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.490	1.500		1.500	1.500	1.500	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.495		
O	3.869	3.879		3.875	3.873	3.8733	3.873		
P	0.115	0.135		.121	.121	.121	.120		
Q	0.115	0.135		.128	.128	.128	.128		
R	0.240	0.260		.252	.252	.252	.251		
S	0.115	0.135		.128	.128	.126	.120		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.247	.2410	.247	.242		
W	0.115	0.135		.127	.127	.124	.129		
X	0.307	0.312		.310	.310	.310	.312"		
Y	0.760	0.765		.760	.760	.760	.764"		
Z	0.352	0.372		.360	.360	.367	.360		
AA	0.470	0.530		.500	.500	.502	.500		
AB	0.615	0.635		.620	.620	.620	.621		
AC	0.053	0.073		.060	.060	.060	.060		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.377	1.377	1.377	1.377		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.250	.250	.250	.240		
AH	0.240	0.260		.250	.250	.250	.250		
AI	2.000	2.020		2.001	2.001	2.001	2.001		
AJ	0.023	0.043		.030	.093	.030	.033		

Accept/Reject

Measured by:	JP/JF	Date:	07/01/27
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Audited by:	EP
Date:	07/01/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
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E	05.12.05	Added dimension AJ	KJ/JLM	JP JF

DART AEROSPACE LTD	Work Order:	30213
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				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.003	8.003	8.003	8.003		
F	0.490	0.510		.498	.505	.500	.500		
G	0.257	0.262	DT8683	.258	.260	.260	.260		
H	0.375	0.380	DT8684	.375	.376	.376	.376		
I	0.490	0.510		.501	.498	.501	.500		
J	1.174	1.184		1.180	1.180	1.180	1.180		
K	0.558	0.578		.570	.563	.567	.570		
L	1.174	1.184		1.178	1.178	1.178	1.178		
M	1.490	1.500		1.500	1.500	1.500	1.500		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.872	3.872	3.872	3.872		
P	0.115	0.135		.125	.121	.123	.123		
Q	0.115	0.135		.125	.135	.135	.135		
R	0.240	0.260		.252	.254	.255	.254		
S	0.115	0.135		.130	.129	.129	.129		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.963	2.963	2.963		
V	0.230	0.250		.247	.248	.244	.243		
W	0.115	0.135		.122	.122	.122	.122		
X	0.307	0.312		.312	.312	.312	.312		
Y	0.760	0.765		.764	.764	.764	.764		
Z	0.352	0.372		.367	.364	.364	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.622	.626	.628	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.251	.249	.250		
AE	1.375	1.395		1.380	1.382	1.384	1.384		
AF	0.115	0.135		.180	.130	.130	.130		
AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.250	.257	.253	.252		
AI	2.000	2.020		.001	.001	.001	.001		
AJ	0.023	0.043		.033	.023	.023	.023		
Accept/Reject									

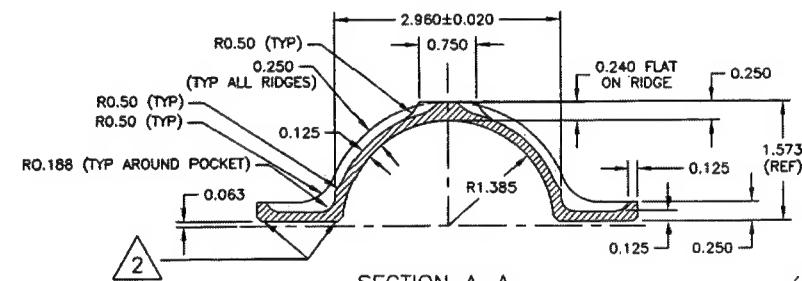
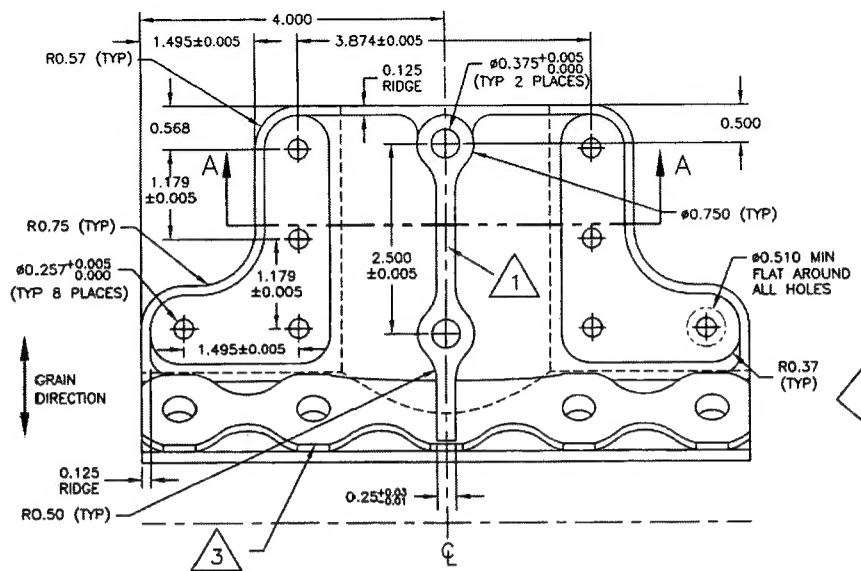
Measured by:	J.F./J.B.	Audited by:	S.
Date:	07/01/26	Date:	07/01/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	J.B.



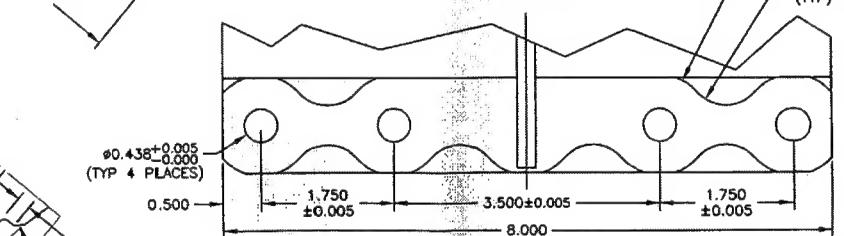
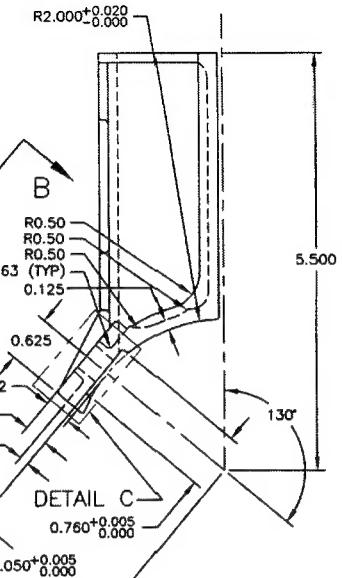
RELEASED

05.12.06



SECTION A-A

DETAIL C  
SCALE 2:1



NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-003)  
FINISH: ACID ETCH, ALDODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C) E

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

DESIGN DS	DRAWN BY PH	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED <input checked="" type="checkbox"/>	APPROVED <input checked="" type="checkbox"/>	DRAWING NO. D2572 REV. E SHEET 1 OF 1
DATE 05.07.13	TITLE INNER FWD SADDLE	SCALE 2:3

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